

Date: Wednesday, 15/08/2007 4:00:28 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: EXTRUSION "I" BEAM WEB 4"	
Jot Number	: 33940		Part Number	: D25003100	
Estimate Number	: 10155		Drawing Number	: D2500 REV G	
P.C. Number	: N/A		Project Number	: N/A	
This Issue	: 15/08/2007 S.O. No. : N/A		Drawing Revision	: G	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 09/09/2007	
Previous Run	: 31223		Qty:	189	
Written By	: <i>[Signature]</i>		Um:	80 Each	
Checked & Approved By	: <i>[Signature]</i>				
Comment	: Est. E 02.09.10 Added DSK 066 KJ est F 07.07.06 rev G dwg EC				

## Additional Product

Jot Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING  <b>Comment:</b> PURCHASING Issue P/O: <i>4374</i> a) Extrude as per Dwg D2500 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 10% f) Order at 100" long g) Caradon Indalex Tool # MS-18867 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required <i>C207108116</i> <i>80</i>
2.0	D25003100P	Ext'n - 'I' Beam Web 4"  <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s) EXTRUSION "I" BEAM WEB 4" <i>C207108116</i> <i>189</i>
3.0	PACKAGING 1	PACKAGING RESOURCE #1  <b>Comment:</b> PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached <i>AWM/</i> <i>SR/ 7-12-S</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes *✓* No  DQA: *DD* Date: *01/12/04*  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:00:28 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EXTRUSION 'I' BEAM WEB 4"

Job Number: 33940

Part Number: D25003100

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per Dwg D2500

Check Pull test per Dwg D2500 for compliance page attached.

Check hardness with Webster tester

7/12/05 189

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L.G.

SR/AWM07-12-05

180

6.0 QC21 FINAL INSPECTION/W/O RELEASE



189

7/12/05

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



7/12/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>#</i>	DRAWN BY <i>PS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2500	REV. G SHEET 1 OF 3
DATE 07.04.17		TITLE EXTRUSION	SCALE NTS
A	96.03.19	NEW ISSUE	
B	96.03.24	CHANGE INTERNAL WEB	
C	96.04.26	ADD D2500-3 WEB	
D	96.10.07	ADD MATERIAL PROPERTIES	
E	96.10.24	CHANGE MATERIAL TEMPER	
F	97.09.29	CHANGE MAT. TO 6061-T6	
G	07.04.17	ADD NOTES 3,5,6	

**RELEASED**  
07.06.28 *#*

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM TENSILE YIELD STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI  
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

2. BREAK ALL SHARP CORNERS 0.010 MAX
3. ALL DIMENSIONS ARE IN INCHES
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH (EX. D2500-1-190 IS 190" LONG)  
D2500-1 EXTRUSION MANUFACTURED FROM:  
A) BON L DIE # 897015 -> PREFERRED *w/0: 33940*  
B) CARADON MIDEAST DIE # PAH-28030  
C) CARADON MTL DIE # MH-18868
6. FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG)  
D2500-3 EXTRUSION MANUFACTURED FROM:  
A) CARADON INDALEX DIE # MS-18867

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

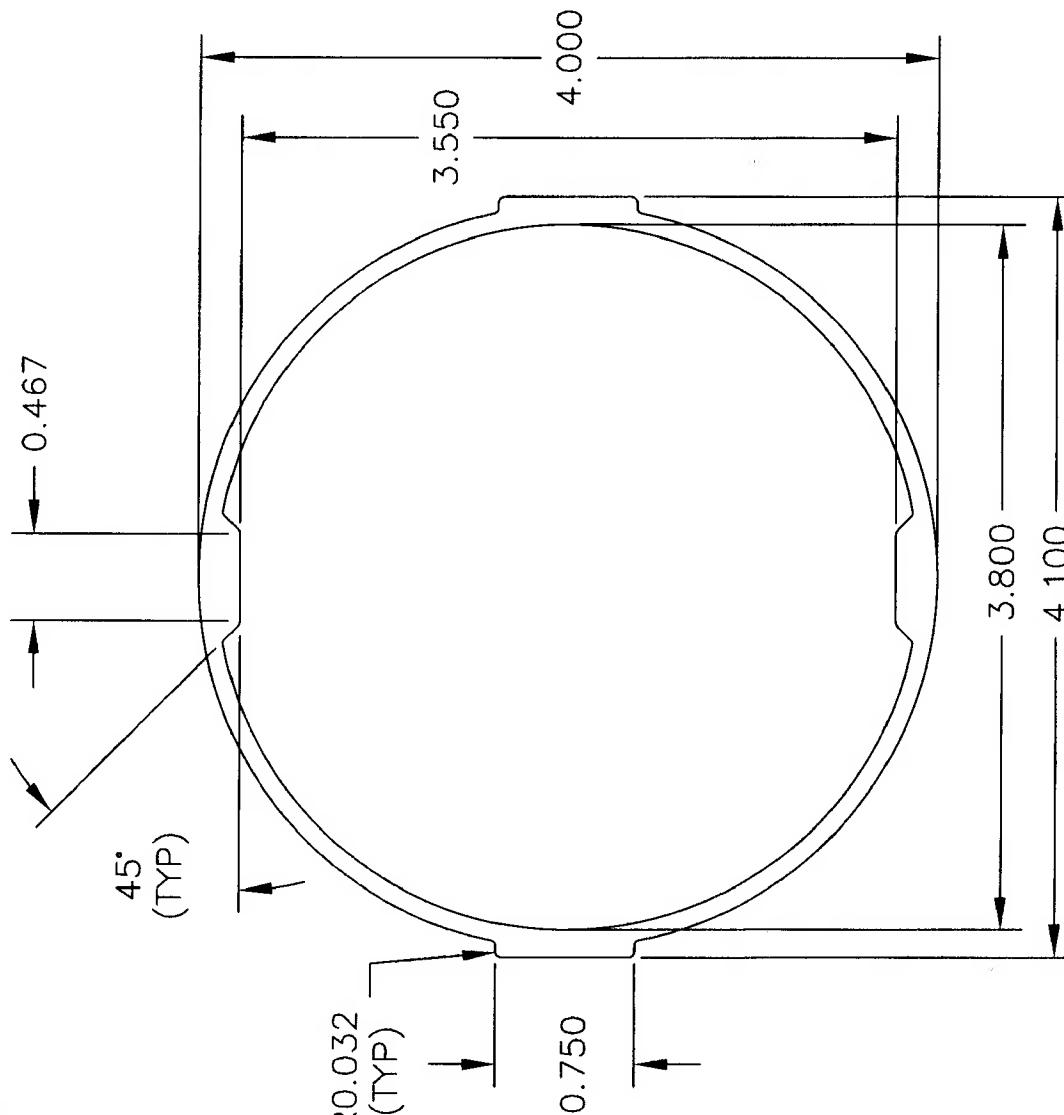
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2500
DATE 07.04.17		TITLE EXTRUSION

REV. G  
SHEET 2 OF 3  
SCALE  
1:1**RELEASED**  
07.06.28

W/O: 33940

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

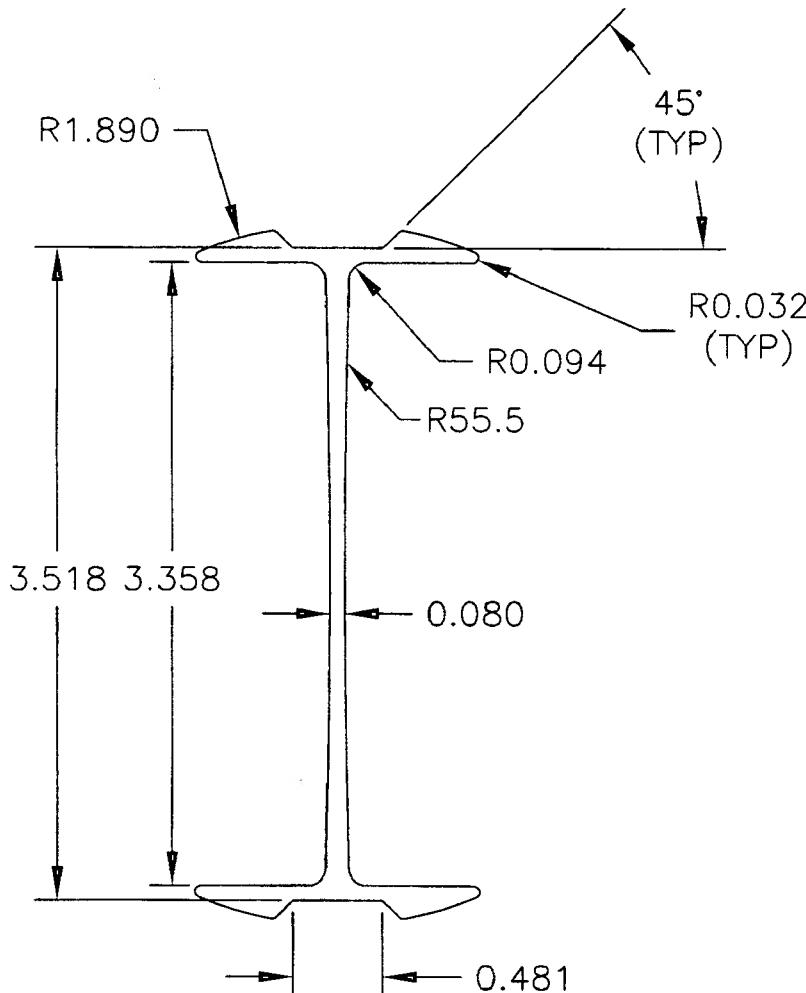
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
checked	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
		D2500	REV. C
DATE		TITLE	SHEET 3 OF 3
07.04.17		EXTRUSION	SCALE
			1:1

**RELEASED**  
01.JL.28



D2500-3



325 rue Avro  
Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120  
Fac-simile (514) 694-8310

## Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : DART AEROSPACE LTD

Adresse / Address : 1270 ABERDEEN STREET  
HAWKESBURY ONT,  
K6A 1K7

# commande Indalex / Indalex order # : 7111793

# bon de commande / Purchase order # : 4374

# de matrice / Die # : MS 18867 Description : D2500-3

Alliage & trempage / Alloy & temper : 6061 T6

# Contrôle / Control # : 62481-1

# Coulée / Cast # : 42082

	Min.requis Min.required	Résultat actuel Actual results
Tension ultime Ultimate stress (psi)	38 000	41292
Contrainte élastique Yield stress (psi)	35 000	38615
% élongation dans 2" % elongation in 2"	8	12
Dureté Rockwell E (hrc) Rockwell E Hardness (hrc)	88 @ 100	92

### Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	TI
6063	0,20 - 0,60	0,35 Max	0,10 Max	0,10 Max	0,45 - 0,90	0,10 Max	0,10 Max	0,10 Max
6005	0,60 - 0,90	0,35 Max	0,10 Max	0,10 Max	0,40 - 0,60	0,10 Max	0,10 Max	0,10 Max
6005A	0,68 - 0,72	0,15 - 0,27	0,08 - 0,12	0,20 - 0,24	0,48 - 0,52	0,03 Max	0,05 Max	0,03 Max
6061	0,40 - 0,80	0,70 Max	0,15 - 0,40	0,15 Max	0,80 - 1,20	0,04 - 0,35	0,25 Max	0,15 Max
6351	0,7 - 1,3	0,5 Max	0,10 Max	0,40 - 0,80	0,40 - 0,80	—	0,20 Max	0,20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et AMS QQA 200/8 excepté pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of specimen) and AMS QQA 200/8 except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre,  
Yours truly,

date : 2007-11-27

Bruno Morency  
Technicien de la qualité  
Quality technician

Indalex Limited

11/27/2007 TUE 11:42 FAX 613 632 4443 DART HELICOPTER SERVICES → DAS - LINDA

001/002

11/27/2007 TUE 11:33 FAX 514 694 8310 Indalex Mtl

001/002



INDALEX LIMITED  
325 AVRO Street  
POINTE-CLAIRE, QC H9R 5W3  
TELEPHONE: (514) 697-5120 & (800) 563-5120  
FACSIMILE: (514) 694-8310 & (800) 563-8310

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FACSIMILE TRANSMITTAL SHEET

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TO: Christina Young  
FROM: Bruno Morency  
Quality Technician

COMPANY: DART AEROSPACE LTD DATE: 2007/11/27

FAX NUMBER: 1(613) 632-4443 TOTAL NO. OF PAGES INCLUDING COVER: 2

PHONE NUMBER: SENDER'S REFERENCE NUMBER:

SUBJECT: REPORT TIME:

URGENT  FOR REVIEW  PLEASE COMMENT  PLEASE REPLY  PLEASE RECYCLE

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NOTES/COMMENTS:

Mechanical properties report

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INDALEX LIMITÉE  
325, RUE AVRO  
POINTE-CLAIRE (QUÉBEC) H9R 5W3  
TÉL.: 514-697-5120 • FAX: 514-694-8310

## PROFILÉS D'ALUMINIUM - ANODISATION - FABRICATION - PEINTURE ALUMINUM EXTRUSIONS - ANODIZING - FABRICATION - PAINTING

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ONT

EXPÉDIÉ / SHIP TO

**INDICATIONS SPÉCIALES  
SPECIAL INSTRUCTIONS**

P/S#: 634835

NOTRE NUMÉRO DE COMMANDE  
OUR ORDER NO. . .

7111793 1

## NEW YORK

K6A1K7

CUSTOMER P.S.T. : \*6122-5207

INDALEX G.S.T. REG NO: R136834041

Required Date:

N° DU CLIENT CUST. NO.	T.P.S. G.S.T.	TAXE DE VENTE PROV. PROV. SALES TAX	N° DE COMM. DU CLIENT CUST. ORDER NO.	DATE DE COMMANDE ORDER DATE	NOTRE DATE DE COMMA OUR ORDER DATE	CONDITIONS TERMS
<b>201355</b>	XXXXXX		<b>4374</b>	<b>7/11/14</b>	<b>7/11/15</b>	

VENDEUR  
SALESMAN EXPÉDIE PAR  
SHIP VIA PAYÉ  
PPD. PERC.  
COL. C.A.D.  
C.O.D. F.A.B.  
F.O.B. EN BALLOTS  
BUNDLED AND TAPE  
CARTONNÉ  
CARTONED  
CARTONNÉ & INTERCALÉ  
CARTONED & INTERLEAVED

N° ITEM ITEM ITEM	COMMANDE / ORDERED POIDS PIECES	N° DE MATRICE INDALEX NO.	DESCRIPTION DU CLIENT CUSTOMER DESCRIPTION	ALLIAGE ET TREMPAGE ALLOY AND TEMPER	LONGUEUR LENGTH	PRIX UNITAIRE UNIT PRICE
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F EXTRUDE ONLY

1 499 167 DUE=2007/11/30 ASAP  
MS 18867 D2500-3-100 6061 T6 254

We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures.

DATE DE LIVRAISON DATE SHIPPED  7/11/28	ENVOYÉ PAR SHIPPED VIA  ONTARIO 29 11 2007
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CONSIGLIO DI VIVERE OGNI GIORNO

**EXEMPLAIRE DE LA COMPTABILITÉ  
ACCOUNTING COPY**

## FRUILLÉ D'ÉTAPACIUTAGE PACKING SWIP